



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

D350-748-203
Job Sheet 197822



Part No: D350-748-203

Job Qty: 1 pcs

Part Name: AS350 / AS355 Stainless Steel Aft Crosstube



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 7/17/19

Job Tracking No:

Created By: Marie Lajeunesse

Due Date: 7/31/19

Type: Stock

Description:

Note: D350-748-243 REV:A IPP REV:A 15.03.23 NEW ISSUE DD VERF;JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier	Sign-off
					Setup Hrs	Run Hrs		
110	Crosstubes - Bend - 1	1 pcs	7/31/19	7/31/19	0.50	2.44	Crosstubes - Bend	
127	QC 15	1 pcs	7/31/19	7/31/19	0.00	0.00	QC 15 - 12	
							QC 15 - 3	
							QC 15 - 47	
							QC 15 - 49	
							QC 15 - 58	
							QC 15 - 9	
							QC 15 - 68	
128	Crosstubes - 3 - B4B	1 pcs	7/31/19	7/31/19	0.00	1.98	Crosstubes - 1 - B4B	
							Crosstubes - 2 - B4B	
							Crosstubes - 3 - B4B	
							Crosstubes - 4 - B4B	
130	Crosstubes - 4 - B4B	1 pcs	7/31/19	7/31/19	0.00	2.89	Crosstubes - 1 - B4B	
							Crosstubes - 2 - B4B	
							Crosstubes - 3 - B4B	
							Crosstubes - 4 - B4B	
140	QC 5	1 pcs	7/31/19	7/31/19	0.00	0.00	QC 5 - 10	
							QC 5 - 12	
							QC 5 - 17	
							QC 5 - 18	
							QC 5 - 19	
							QC 5 - 22	
							QC 5 - 24	
							QC 5 - 3	
							QC 5 - 43	
							QC 5 - 49	
							QC 5 - 51	
							QC 5 - 58	
							QC 5 - 68	
							QC 5 - 9	
							QC 5 - 50	



Container No: S225402



Part: D350-748-203

Job No: 197822

Serial No/Batch: S225402

Revision: A

Inspector:

Exp Date:

Instructions: TC STC SH06-27 Issue 2, FAA STC SR023591

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CANADA
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				QC 5 - 30		DAS
				QC 5 - 40	NOV 14 2019	40
				QC 5 - 61		9-89
				QC 5 - 81		
174 Outsource - 2 - NDT per QSI038	1 pcs	7/31/19		SKY002-VC		2019-11-15
176 Packaging 2-1 - Recelve - B4B	1 pcs	7/31/19	0.00 0.00	Packaging 2 - 1 - B4B		
				Packaging 2 - 2 - B4B		
				Packaging 2 - 3 - B4B		
				Packaging 2 - 5 - B4B		
				Packaging 2 - 4 - B4B		NOV 15 2019
				Packaging 2 - 6 - B4B		
				Packaging 2 - 7 - B4B		
				Packaging 2 - 8 - B4B		
				Packaging 2 - 9 - B4B		
				Packaging 2 - 10 - B4B		
				Packaging 2 - 11 - B4B		
				Packaging 2 - 12 - B4B		
				Packaging 2 - 13 - B4B		
				Packaging 2 - 14 - B4B		
				Packaging 2 - 15 - B4B		
				Packaging 2 - 16 - B4B		
				Packaging 2 - 17 - B4B		
				Packaging 2 - 18 - B4B		
				Packaging 2 - 19 - B4B		
				Packaging 2 - 20 - B4B		
				Packaging 2 - 21 - B4B		
				Packaging 2 - 22 - B4B		
				Packaging 2 - 23 - B4B		
				Packaging 2 - 24 - B4B		
				Packaging 2 - 25 - B4B		
				Packaging 2 - 26 - B4B		
				Packaging 2 - 27 - B4B		
				Packaging 2 - 28 - B4B		
				Packaging 2 - 29 - B4B		
				Packaging 2 - 30 - B4B		
				Packaging 2 - 31 - B4B		
				Packaging 2 - 32 - B4B		
				Packaging 2 - 33 - B4B		
				Packaging 2 - 34 - B4B		
				Packaging 2 - 35 - B4B		
				Packaging 2 - 36 - B4B		
178 QC 6	1 pcs	7/31/19	0.00 0.00	QC 6 - 9		
				QC 6 - 68		
				QC 6 - 61	DAS	
				QC 6 - 40	81	
				QC 6 - 81	9-89	
180 Spray Paint - 2 - B4B	1 pcs	7/31/19	0.00 1.07	Spray Paint - 1 - B4B	DAS	NOV 18 2019
				Spray Paint - 2 - B4B	41	
				Spray Paint - 3 - B4B	9-89	
				Spray Paint - 4 - B4B		
190 QC 14	1 pcs	7/31/19	0.00 0.00	QC 14 - 15		
				QC 14 - 2		
				QC 14 - 34		
				QC 14 - 41		
				QC 14 - 51		
				QC 14 - 58		
				QC 14 - 59		
				QC 14 - 9		

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				QC 14 - 68	NOV 18 2019	68
				QC 14 - 40		9-89
				QC 14 - 19		
				QC 14 - 43		
				QC 14 - 24		
				QC 14 - 61		
				QC 14 - 81		
200	Crosstubes - 5 - B4B	1 pcs	7/31/19	0.00 2.89	Crosstubes - 1 - B4B	
					Crosstubes - 2 - B4B	
					Crosstubes - 3 - B4B	DAS
					Crosstubes - 4 - B4B	41 NOV 18 2019
210	QC 5	1 pcs	7/31/19	0.00 0.00	QC 5 - 10	3-89
					QC 5 - 12	
					QC 5 - 17	
					QC 5 - 18	
					QC 5 - 19	
					QC 5 - 22	
					QC 5 - 24	
					QC 5 - 3	
					QC 5 - 43	
					QC 5 - 49	
					QC 5 - 51	
					QC 5 - 58	
					QC 5 - 68	DAS
					QC 5 - 9	NOV 20 2019
					QC 5 - 50	68
					QC 5 - 30	9-89
					QC 5 - 40	
					QC 5 - 61	
					QC 5 - 81	
220	Packaging 1-1 - Pick Kit - B4B	1 pcs	7/31/19	0.00 0.00	Packaging 1 - 1 - B4B	✓ Oscar
					Packaging 1 - 2 - B4B	
					Packaging 1 - 3 - B4B	
					Packaging 1 - 4 - B4B	
					Packaging 1 - 5 - B4B	
					Packaging 1 - 6 - B4B	
					Packaging 1 - 7 - B4B	
					Packaging 1 - 8 - B4B	
					Packaging 1 - 9 - B4B	
					Packaging 1 - 10 - B4B	
					Packaging 1 - 11 - B4B	
					Packaging 1 - 12 - B4B	
					Packaging 1 - 13 - B4B	
					Packaging 1 - 14 - B4B	
					Packaging 1 - 15 - B4B	
					Packaging 1 - 16 - B4B	
					Packaging 1 - 17 - B4B	
					Packaging 1 - 18 - B4B	
					Packaging 1 - 19 - B4B	
					Packaging 1 - 20 - B4B	
					Packaging 1 - 21 - B4B	
					Packaging 1 - 22 - B4B	
					Packaging 1 - 23 - B4B	
					Packaging 1 - 24 - B4B	
					Packaging 1 - 25 - B4B	
					Packaging 1 - 26 - B4B	
					Packaging 1 - 27 - B4B	
					Packaging 1 - 28 - B4B	
					Packaging 1 - 29 - B4B	

NOV 20 2019

					Packaging 1 - 30 - B4B	
					Packaging 1 - 31 - B4B	
					Packaging 1 - 32 - B4B	
					Packaging 1 - 33 - B4B	
					Packaging 1 - 34 - B4B	
					Packaging 1 - 35 - B4B	
					Packaging 1 - 36 - B4B	
230 QC 4	1 pcs	7/31/19	0.00 0.00	QC 4 - 28		
				QC 4 - 58		
				QC 4 - 69		
				QC 4 - 9		
				QC 4 - 46		
				QC 4 - 68		
				QC 4 - 72		
				QC 4 - 74		
				QC 4 - 75		
240 Packaging 3-1 - Stock - B4B	1 pcs	7/31/19	0.00 0.00	Packaging 3 - 1 - B4B		
				Packaging 3 - 2 - B4B		
				Packaging 3 - 3 - B4B		
				Packaging 3 - 4 - B4B		
				Packaging 3 - 5 - B4B		
				Packaging 3 - 6 - B4B		
				Packaging 3 - 7 - B4B		
				Packaging 3 - 8 - B4B		
				Packaging 3 - 9 - B4B		
				Packaging 3 - 10 - B4B		
				Packaging 3 - 11 - B4B		
				Packaging 3 - 12 - B4B		
				Packaging 3 - 13 - B4B		
				Packaging 3 - 14 - B4B		
				Packaging 3 - 15 - B4B		
				Packaging 3 - 16 - B4B		
				Packaging 3 - 17 - B4B		
				Packaging 3 - 18 - B4B		
				Packaging 3 - 19 - B4B		
				Packaging 3 - 20 - B4B		
				Packaging 3 - 21 - B4B		
				Packaging 3 - 22 - B4B		
				Packaging 3 - 23 - B4B		
				Packaging 3 - 24 - B4B		
				Packaging 3 - 25 - B4B		
				Packaging 3 - 26 - B4B		
				Packaging 3 - 27 - B4B		
				Packaging 3 - 28 - B4B		
				Packaging 3 - 29 - B4B		
				Packaging 3 - 30 - B4B		
				Packaging 3 - 31 - B4B		
				Packaging 3 - 32 - B4B		
				Packaging 3 - 33 - B4B		
				Packaging 3 - 34 - B4B		
				Packaging 3 - 35 - B4B		
				Packaging 3 - 36 - B4B		
245 DC - 1 - B4B	1 pcs	7/31/19	0.00 0.00	DC - 1 - B4B		
				DC - 2 - B4B		
250 QC 21 - FG	1 pcs	7/31/19	0.00 0.00	QC 21 - FG - 21		
				QC 21 - FG - 70		
				QC 21 - FG - 53		

Part Op 110 - CNC Alpha 160 Bender - Bend tube as per Dwg D350-748-243 using CNC bender program D350A and Folio
 Descriptions: FT_____*****UNDER BEND .225" PER SIDE***** *****USE (4) DT9824 SHIM BLOC TO CHECK STRAIGHTNESS*****

127 - QC15- Crosstube Dimensional Check ***MARK CUT LINES***

128 - Crosstubes - CUT TUBE AT HEIGHT ON FAI SHEET VERF HEIGHT 31.1875 BY QC 15 LEVEL INSPECTOR

130 - Crosstubes - 1- Drill Tube as per Dwg D350-748-243 Using DT8876 Drill Jigs, set-up drill table as per QSI 010. 2- Deburr 3- Engrave Part # and Batch # as per Dwg D350-748-243 4- Remove all marks from tube within limits of D350-748-243

140 - QC5- Inspect part completeness to step on W/O

174 - ISSUE P/O TO SKY SERVICE: 45097

176 - Receive & Inspect for Damage & Mat'l Certs

178 - QC6- All purchased or subcontracted products

180 - Spray Paint / NDT Room ***VERIFY BY RO BATCH # TO MATCH W/O 197822 ***MASK

SCRIBE B# & P# AND VERIFY*** 1. Apply Axalta 13205S Cleaner inside and outside crosstube per QSI 005 4.1.4

BATCH: 5138949 2. Axalta 230S Metalok inside and outside crosstube per QSI 005 4.1.4 BATCH: M138021 3.Prime inside and outside crosstube per QSI 005 4.2 BATCH: 5187223 4. Paint outside of crosstube per QSI 005 4.2BATCH: 5231052190 - QC14- Inspect Spray Paint - Then, Wrap in plastic bag to protect from scratches ***VERIFY BY 68 BATCH # TO MATCH W/O 197822

200 - Crosstubes - INSTALL GROUND WIRE INSERT, THEN INSERT SCREW AND WASHER ***LIMIT AIR PRESSURE TO 50 PSI WHEN INSTALLING AETC-1032 INSERT AND ONLY EXPAND INSERT ONCE*** 1- Abrade mating surfaces

of support and crosstube with 180 grit sandpaper, clean the area with MEK or equivalent as per dwg 2-Install supports

with Proseal 890 per D350-748-243 and QSI 015 A/R Proseal 890 Batch: 5229895 EXP: 3/20 3-

Install supports clamps Using Dt8876 as per Dwg D350-748-243, Torque to 60-80 IN-LBS. PROSEAL CURE TIME 72

HOURS: Start: 19-11-17 Finish: 19-11-20

210 - QC5- Inspect part completeness to step on W/O ***RE-CHECK TORCQUE ON CLAMP AFTER PROSEAL HAS CURED FOR 72HOURS AS PER DWG.*** ***VERIFY BY _____ BATCH # TO MATCH W/O _____

220 - Pick Kit

230 - QC4- 100% Inspect kits for completeness ***VERIFY BY _____ BATCH # TO MATCH W/O _____

240 - Identify and pack for shipping as per PPPD350-748-203 Location: _____ PPP Rev: _____

245 - Document Control - Photocopy bluefile & type labels per PPPD350-748-203 CHG001

250 - QC21- Final Inspection - Work Order Release

Job BOM

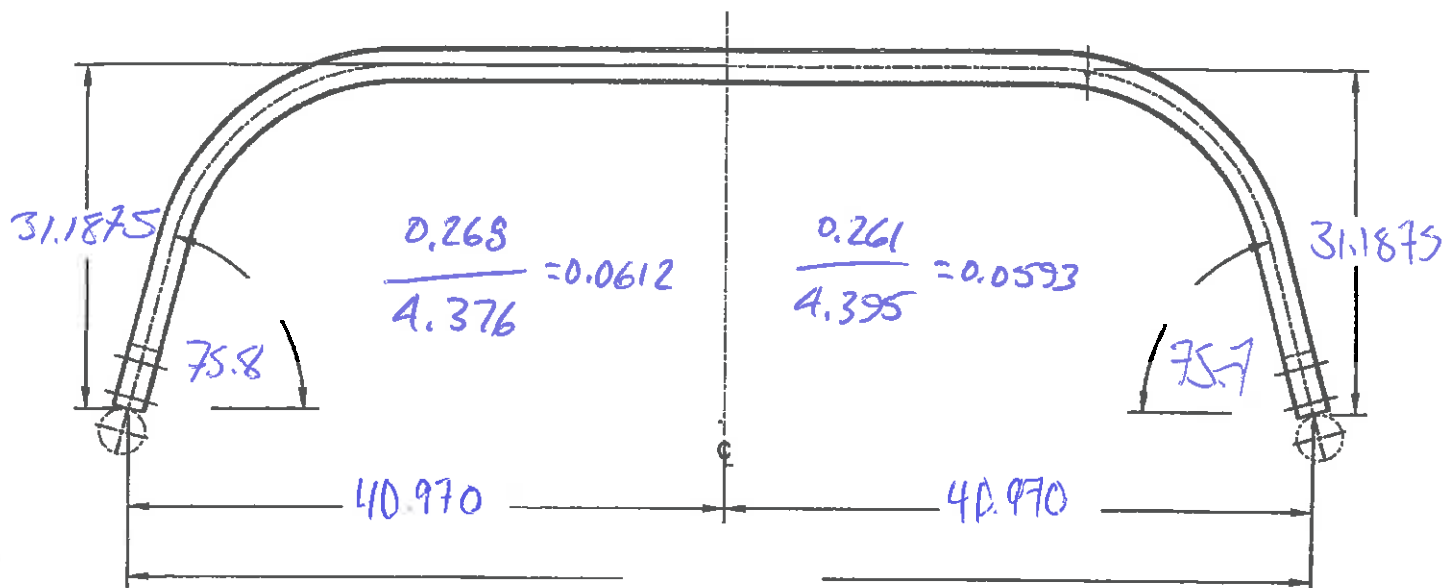
Part / Item	Component Name	Quantity	Operation	Container
D350-748-243TRN	Crosstube Installation, High Aft	1 pcs (1 ea)	110-Crosstubes - Bend - 1	<u>5219217</u>
AETC-1032	Insert	1 Ea (1 ea)	200-Crosstubes - 5 - B4B	<u>FM137335</u>
D3502-1	Support	2 pcs (2 ea)	200-Crosstubes - 5 - B4B	<u>5188464</u>
D5123-7	Clamp Cushion	2 pcs (2 ea)	200-Crosstubes - 5 - B4B	<u>163264</u>
MS21920-20	Clamp	2 Ea (2 ea)	200-Crosstubes - 5 - B4B	<u>503843</u>
NAS1149C0363R	Washer (AN960C10)	1 Ea (1 ea)	200-Crosstubes - 5 - B4B	<u>5181423</u> <u>M138326</u>
MS51958-63	Screw	1 pcs (1 ea)	200-Crosstubes - 5 - B4B	<u>FM134962</u>
AN4-41A	Bolt	8 Ea (8 ea) ✓	220-Packaging 1-1 - Pick Kit - B4B	<u>3058981</u> ✓
AN4-5A	Bolt	16 Ea (16 ea) ✓	220-Packaging 1-1 - Pick Kit - B4B	<u>3228778</u> ✓
AN5-32A	Bolt	4 Ea (4 ea) ✓	220-Packaging 1-1 - Pick Kit - B4B	<u>3119858</u> ✓
D3500-1	Saddle	4 pcs (4 ea) ✓	220-Packaging 1-1 - Pick Kit - B4B	<u>5133673</u> ✓
D3504-1	Bushing	16 pcs (16 ea) ✓	220-Packaging 1-1 - Pick Kit - B4B	<u>5217032</u> ✓
MS21042L4	Nut	24 Ea (24 ea) ✓	220-Packaging 1-1 - Pick Kit - B4B	<u>5228617</u> ✓
MS21042L5	Nut	4 Ea (4 ea) ✓	220-Packaging 1-1 - Pick Kit - B4B	<u>5214642</u> ✓
MS1149D0463J	Washer	32 Ea (32 ea) ✓	220-Packaging 1-1 - Pick Kit - B4B	<u>3229798-1</u> ✓
NAS1149D0563J	Washer	8 Ea (8 ea) ✓	220-Packaging 1-1 - Pick Kit - B4B	<u>5174288</u> ✓

Job Allocations				
Operation	Component Part	Required	Inventory	Allocated
110-Crosstubes - Bend - 1 200-Crosstubes - 5 - B4B	D350-748-243TRN	1	3	0
	AETC-1032	1	12	0
	D3502-1	2	26	0
	D5123-7	2	251	0
	MS21920-20	2	67	0
	MS51958-63	1	39	0
	NAS1149C0363R	1	695	0
	AN4-41A	8	281	0
	AN4-6A	16	447	0
	AN5-32A	4	277	0
220-Packaging 1-1 - Pick Kit - B4B	D3500-1	4	31	0
	D3501-1	16	287	0
	MS21042L4	24	3,020	0
	MS21042L5	4	401	0
	NAS1149D0463J	32	4,300	0
	NAS1149D0563J	8	2,158	0
Part Specifications				
Specifications could not be found.				

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DART AEROSPACE LTD		Work Order: 197822
Description: Crosstube High Aft, SS (AS350/355)		Part Number: D350-748-203
Inspection Dwg: D350-748-243	Rev: A	Page 1 of 1

Required Dimension	Min	Max
Height	31.10	31.60
1/2 Span	40.77	41.03
Angle	75	77
Total Span	81.54	82.06
Bending Passes	7	--
Crushing	--	8%
Twist	--	0.38



	Side A	Side B
Bending Passes	8	
Crushing	6.1%	5.9%
Comments		
Twist 0.047"		

2.054
2.322

2.067
2.328

QC15 Inspection		DAS
Date		68
		9-89 OCT 30 2019

Rev	Date	Change	Revised by	Approved
A	15.09.09	New Issue	KJ	

Item	Qty	Part Number	Description
-243			
1	X	D350-748-243	CROSSTUBE ASSEMBLY (AS 350/355 HI AFT)
2	1	D8021-125	CROSSTUBE
3	2	D3502-1	SUPPORT
4	2	D6123-7	CLAMP CUSHION
5	1	AETC-1032	INSERT
6	2	MS21920-20	CLAMP
7	1	OR MS21920-21/-22	(PER DART SPEC. M-MS21920-20/-21/-22)
8	1	NAS1149C0363R	WASHER (OR AN800C10)
9	1	NAS1635-3-8	SCREW (OR MS61988-63)
9	AR	PROSEAL 880 B-2	SEALANT, AMS-S-8802 CLASS B-2

GENERAL NOTES:

- 1) MATERIAL: MANUFACTURED FROM D8021-125
FINISHED LENGTH AFTER TURNING = 124.70±0.06 (AFTER BENDING/TRIMMING = 122.70 REF)
- 2) FINISH: PRIME INSIDE AND OUTSIDE PER DART QSI 005 4.2
PAINT OUTSIDE PER DART QSI 005 4.2
- 3) TOLERANCE: PER DART QSI 018 UNLESS OTHERWISE NOTED.
WALL THICKNESS ECCENTRICITY PER DART QSI 038 7.2
MIN. ALLOWABLE WALL IS 0.020 FROM NOMINAL
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED.
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX.
- 6) IDENTIFICATION: DART PART NUMBER "D350-748-243" AND BATCH NUMBER ON INSIDE OF CUFF
PER DART QSI 044 8.4 (VIBRATING STYLUS)
- 7) WEIGHT: 28.85 lbs
- 8) PART IS SYMMETRIC ABOUT CENTERLINE, EXCEPT FOR Ø0.200 HOLE.
- 9) EXTREME CARE MUST BE TAKEN TO PROTECT THE OUTSIDE SURFACE OF THE TUBE. THE OUTSIDE SURFACE MUST BE SMOOTH AND FREE FROM SURFACE DEFECTS SUCH AS SCRATCHES, NICKS, OR DENTS. DEFECTS UP TO 0.005" MAY BE BLEND OUT LONGITUDINALLY. CIRCUMFERENTIAL GRIND MARKS ARE UNACCEPTABLE. WHEN DRILLING HOLES EXTREME CARE MUST BE TAKEN AND CAREFUL DEBURRING PERFORMED TO ENSURE A CLEAN HOLE WITH NO CRACKING/CHIPPING/GROOVES.
- TURNING
- 10) BLEND OUT ALL EDGES FROM MACHINING LONGITUDINALLY, TRANSITION SHOULD BE SMOOTH. NOTE: ALL HOLES ARE DRILLED AFTER BENDING.
- BENDING
- 11) BEND PROGRESSIVELY WITH A MINIMUM OF 7 PASSES PER SIDE. MAXIMUM TUBE FLATTENING DUE TO BENDING IS 6% BASED ON O.D. ON TOP HALF OF BEND, AND 8% ON BOTTOM HALF OF BEND.
- 12) MAX AMPLITUDE OF RIBBLING ALONG BENT PORTION OF THE TUBE IS 0.030 (2N A1-3)
- 13) MAX TWIST: WITH TUBE LAYED FLAT ON SURFACE, THE DIFFERENCE BETWEEN CUFF HEIGHTS FROM THE SURFACE MAY BE NO LARGER THAN 0.38 (2N C1-3).
- ASSEMBLY
- 14) TO INSTALL D3502-1 SUPPORT: ABRASE MATING SURFACE OF SUPPORT AND CROSSTUBE WITH 180-GRIT SANDPAPER AND REMOVE RESIDUE WITH MEK (OR EQUIVALENT). APPLY A 0.02" TO 0.05" THICK LAYER OF PROSEAL 880 CLASS B-2 (OR AMS-S-8802 CLASS B-2) SEALANT TO MATING SURFACE OF SUPPORT.
- 15) TORQUE CLAMPS 80 TO 80 IN-LB. ENSURE AT LEAST 1.5 THREADS SHOWING IN SAFETY AND THAT NUT HAS NOT BOTTOMED-OUT AFTER TORQUING. PRIOR TO PACKAGING, RE-CHECK TORQUE ON CLAMPS AFTER PROSEAL 880 SEALANT HAS CURED FOR 72 HOURS.

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED
SUBJECT TO AMENDMENTS
WITHOUT NOTICE
WORK ON DRAWING
NO. 197822 MVS
1907-17

DEO ATTACHED

RELEASED
2015 MAR 18

RELEASED

2015 MAR 18
OK
REV 15/04/07 9/14/09

UNDER REVIEW

OK
REV 15/04/07 9/14/09

A	NEW ISSUE	CP	BY	DATE
REV.	DESCRIPTION			
DESIGN				
DRAWN				
CHECKED				
MFG. APPR.				
APPROVED				
DE APPR.				
DATE	15.01.21			

DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	REV. A
DRAWING NO. D350-748-243	SHEET 1 OF 4
TITLE	SCALE
CROSSTUBE (AS 350/355 HI AFT)	NTS
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DRAWING NO. D350-748-243	TITLE CROSSTUBE	REV. A	DART AEROSPACE LTD ENGINEERING ORDER		D.E.O. NO. D350-748-243-A-1	SHEET NO. SHEET 1 OF 1	SCALE NTS
DRAWN 90	CHECKED A.S.		MFG. APPR. <i>[Signature]</i>	APPROVED <i>[Signature]</i>		DE APPR. <i>[Signature]</i>	
DATE 15.11.18	DATE 15.11.18		DATE 16.02.19	DATE FEB 19 2016		DATE 2016.02.19	

AMEND NOTE 2 (SHEET 1) AS FOLLOWS:

- 2) FINISH: PREPARE SURFACE PER DART QSI 005 4.1.4
 PRIME INSIDE AND OUTSIDE PER DART QSI 005 4.2
 PAINT OUTSIDE PER DART QSI 005 4.2
 OR
 POWDER COAT WHITE (4.3.5.2) PER DART QSI 005 4.3

RELEASED
 2016-02-26
 6-534

Entered: _____

Date: _____

WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____		DISPOSITION ☐ Rework ☐ Scrap ☐ Use-as-is ☐ Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality		DEPARTMENT/PROCESS		MRB (QSI042)	
Date : _____		Sequence #: _____		QTY Affected : _____			
Description Work Order Deviation		Disposition					
Completed By		Lead hand / Supervisor					
QC / QA Coordinator		_____					

Root Cause		FAULT CATEGORY									
Operator	☐	Pressure/Forced	☐	Contamination	☐	Power Loss/Surge	☐	Positioned Wrong	☐		
Manufacturing Process	☐	Bending	☐	Misaligned/off center	☐	Folio/Program	☐	Outside Tolerance	☐		
Equip/Tooling	☐	Crushing	☐	BOM/Route	☐	Grain Direction	☐	Drawing	☐		
Handling/Preservation	☐	Cracks	☐	Broken/Damage/Defect	☐	Weld	☐	Finish	☐		
Material	☐	Crimp/Kink/Ripple/Wave/Twist	☐	Incomplete/Unclear Instructions	☐	Wrong Stock Pulled	☐	Part Lost/Missing	☐		
Product Improvement	☐	Marks/Chatter	☐	Drill Holes	☐	Out of Sequence	☐	Misread	☐		
Process Improvement	☐	Mislabeled	☐	Fit/Function	☐	Off-set/Set-up	☐				
Human Factors	☐	Other/Details:									



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Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER **POHB045097**



Supplier: SKY002-VC
Skyservice
6120 Midfield Road
Mississauga
ON
L5P 1B1 Canada
Phone: 905-678-5636
Fax: 905-678-5841

Attention: Jenne, Heather

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

PO No: POHB045097

PO Date: 11/13/19

Due Date: 11/15/19

**Purchase Order
Revision:**

Revision Date:

Ship-To Contact: Guerin, Kimberley
Phone: 613-632-5200 Ext: 298
kguerin@dartaero.com

Via: Ground

Pymt Terms: Net 30

Freight Terms:

Special Comments:

Items												
Line Item	Job	Part	Drawing	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
1	196268	D350-748-203	D350-748-243 Rev A	AS350 / AS355 Stainless Steel Aft Crosstube : TC STC SH06-27 Issue 2, FAA STC SR02359NY 11/03/04, EASA STC EASA.10016903 Revision 2 10/09/03, BRAZIL 2009S04-04 09/04/06 ISSUE P/O TO SKY SERVICE:	Firmed X1	-	11/15/19	1 pcs	0 pcs	1 pcs	\$278.3333/pcs	\$278.33
	200616				Firmed X	-	11/15/19	1 pcs	0 pcs	1 pcs	\$278.3333/pcs	\$278.33
	197822				Firmed X	-	11/18/19	1 pcs	0 pcs	1 pcs	\$278.3333/pcs	\$278.33
Sub Total:								3	0	3		\$835.00
Grand Total:											\$835.00	

Order Notes

Procurement Quality Clauses
A005 right of entry
A012 chemical and physical test report
A016 personnel qualification
A017 raw material identification (as applicable)

A022 Apical Processing
A024 process certifications
A026 certification of material conformance

A041 quality management system
A042 dart notification by supplier
A043 retention of quality documents

A048 counterfeit parts avoidance, detection, mitigation and disposition program

A049 supplier awareness

Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.

Plex 11/15/19 10:24 AM Dart.Guerin.Kimberley

**skyservice****Work Order Traveler**
Sky Service F.B.O. Inc.

10105 Ryan Avenue, Dorval, Quebec, H9P 1A2

TCCA AMO 53-89 / EASA 145.7142 / BDA AMO 385

WO #: MWC 545	Customer: Dart Aerospace Ltd.	Dept: NDT YUL	Reference: POHB045097
Descr:	PN:	S/N:	Qty: 1
Make:	Model:	Reg:	A/C S/N:
TSN:	CSN:	TSO:	
Task: UNSCHEDULED			Sequence: 1

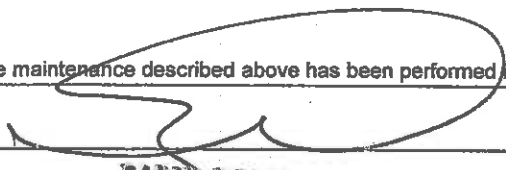
Work Required:

CARRY OUT NDT ON 3 STAINLESS STEEL AFT CROSSTUBES P/N: D350-748-203 , J/S:
196268 , 197822 , 200616

Action Taken:	Date:	Initial/Stamp:				
LPI C/O IAW ASTM E-1417M-16 ***NO CRACK FOUND*** PEN. ZL-67, MPO25403, CLEANER SKC-S MPO13923 , DEV. MPO11715 , UV LIGHT M-20142	NOV 15 2019					
Miscellaneous AD Review Performed: ☐ No applicable AD's noted ☐ Refer to action taken for applicable AD's						
Description	Location	P/N	Qty	Batch	S/N Off	S/N On

DAS
81
9-89

I certified that the maintenance described above has been performed in accordance with the applicable standard of airworthiness.

Signature: 	ACA/SCA Stamp	Date:
Name: RAFIK MELIKIAN		NOV 15 2019